

D3173-041

DART AEROSPACE LTD	Work Order:	20380
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	3
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Note: K10017 Kits to be made in multiples of 4. (1) K10017 Kit consists of (2) D3175-041 and (2) D3178-041.</b>	JH	04.02.16	3
2	MV	Cut blanks: 3.00" x 1.520" Material: 5052-H32/H34 sheet (QQ-A-250/8) 0.063" thick (M5052H32S.063) <b>(Cut 1 stack of 8 per (4) K10017)</b> Identify as D3178-1 Batch:			
3	MV	Cut blanks: 2.5" x 1.5" x 2.2" ( <b>grain along 2.2"</b> ) Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) (M6061T6B1.500x02.500) <b>(Cut 16 blanks per (4) K10017)</b> Identify as D3175-1 Batch: <b>(Note: (2) D3175-1 are required per D3175-041 assembly)</b>			
4	MV	Cut blanks: 2.125" x 1.250" Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) <b>(Cut 8 blanks per (4) K10017)</b> Identify as D3175-3 Batch:			
5	MV	Machine D3178-1 as per Folio FA296 and Dwg D3178			
6	QC2	Inspect parts as they come off the CNC machine			
7	QC8	Second inspection			
8	MV	Machine D3175-1 as per Folio FA293 and Dwg D3175			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr and Tumble			
11	QC8	Second inspection			
12	MV	Machine D3175-3 as per Folio FA294 and Dwg D3175			
13	QC2	Inspect parts as they come off the CNC machine			
14	MV	Deburr and Tumble			
15	QC8	Second inspection			
16	GA	C'sink D3178-1 holes as per Dwg D3178			
17	GA	Deburr stack of D3178-1			
18	QC5	Inspect C'sink			
19	FP	Chemical Conversion Coat D3178-1, D3175-1 & D3175-3 per QSI 005 4.1			

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries  
H:\Admin-QAISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	20380
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	3

Page 2 of 2

Step	Location	Procedure	By	Date	Qty
20	QC3	Inspect Conversion Coat			
21	GA	Assemble D3178-041 as per Dwg D3178 <b>Pick:</b> Qty      Part Number      Description      Batch 16      MS20426AD3-4      Rivet      _____ 8      MS21059L3      Nut Plate      _____  <b>Identify as D3178-041</b>			
22	QC5	Inspect D3178-041 Assembly			
23	GA	Assemble D3175-041 as per Dwg D3175 <b>Pick:</b> Qty      Part Number      Description      Batch 4      AN3-7A      Bolt      _____ 8      AN960JD10L      Washer      _____ 4      MS21042L3      Nut (or -3)      _____  <b>Identify as D3175-041</b>			
24	QC5	Inspect D3175-041 Assembly			
25	FP	Powder Coat D3175-041 Only Gloss White (Ref: 4.3.5.1) per QSI 005 4.3			
26	QC3	Inspect Powder Coat			
27	PK	<b>Identify and Stock as K10017.</b> <b>Note: (1) Kit consists of (2) D3175-041 and (2) D3178-041.</b> Part Number      Description      Qty D3175-041      Mounting Lug      _____ D3178-041      Nut Plate      _____			
28	AC	Parts to stock and Prorate cost to parts per Step 27. Cost / part <u>      </u>		SUCOY-02-17	
29	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	03.01.28	New issue	KJ/RF	
B	03.02.28	Modify Step 1,2,3,4,21,23	KJ/RF <u>PF</u>	<u>J</u>

RELEASED  
03.02.04 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 16, 2004  
01:36 pm

Work Order No	:	0020380	Department Code:		
Project Name	:	*K10017	Burden Flags	:	NNNNNNN
Project For	:	WK409412	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	*K10017	Invoice Number	:	
Description	:	Mtg Lug/Nut Plate Kit	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	3			
Amount Done	:	0	Order Entry No	:	
Start Date	:	02-16-04	OE Value	:	0.00
Est Finish Date	:	02-26-04			
Act Finish Date	:		Est Margin	:	0.000%
Drawings Reqd	:	No	Actual Margin	:	0.000%
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
Burden	:	0.00	0.00	0.00	
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00